



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3915-041

Job Sheet 195016



Part No: D3915-041

Job Qty: 1 pcs

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV F SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	6/20/19		0.00	3.33	Large Fab - 1		SEP 16 2019
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3	DAS	
							Large Fab - 4	24	
							Large Fab - 5	9-89	
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	6/20/19		0.00	0.00	Large Fab - 9		DAS 43 9-89
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
120	QC 5	1 pcs	6/20/19		0.00	0.00	QC 9 - 9		DAS 43 3-89
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S213854



Part: D3915-041

Job No: 195016

Serial No/Batch: S213854

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/16/19

Plex 5/13/19 10:50 AM Dart.lajeunesse.marie

130 Handfinish - 1-1 Chemical- B4B	1 pcs	6/20/19	0.00 1.00	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140 Large Fab - Welded Assy-2- B4B	1 pcs	6/20/19	0.00 3.33	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
150 QC 9	1 pcs	6/20/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
155 QC 5	1 pcs	6/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	

SEP 17 2019

DAS
24
9-89

SEP 19 2019

DAS
43
9-89

					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	DAS
					QC 5 - 49	43
					QC 5 - 51	2-00
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
157	Handfinish - 1-2- Chemical-B4B	1	6/20/19	0.00 1.00	Handfinish - 1 - 1 - B4B	
	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SEP 24 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White Gl(A)-B4B	1	6/20/19	0.00 0.83	Powdercoat - 1 - B4B	
	pcs				Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	1	6/20/19	0.00 0.00	QC 3 - 10	
	pcs				QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	

						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	BEB 19-09-25
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
180 Handfinish - 4-1-Assembly-B4B	1	pcs	6/20/19	0.00	0.81	Handfinish - 4 - 1 - B4B	
						Handfinish - 4 - 10 - B4B	BEB 19-09-26
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
190 QC 5	1	pcs	6/20/19	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
200 Packaging 3-1 - Stock - B4B	1	pcs	6/20/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	

DAS
59
COCDAS
40

SFP 26 2019 9-89

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	BEB 19-08-09-26
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA		1	6/20/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

DAS SEP 26 2019

21

Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: 13878) 1- assemble ribs , weld as per dwg D3915 using DT9606A. When
Descriptions: welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of
D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF
CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge,
label plate and Mounting plates as per dwg D3915
110 - (QC9- Inspect visual per QSI004- Fusion Welds)
120 - (QC5- Inspect part completeness to step on W/O) -Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high
lettering per QSI 044 6.4
130 - (Chemical Conversion Coat per QSI005 4.1) *ENSURE TO RINSE CAREFULLY ACID AND ALODINE*****
140 - (Weld per dwg A/R Aluminum rod Batch:) 1- weld (4) corners
150 - (QC9- Inspect visual per QSI004- Fusion Welds)
155 - (QC5- Inspect part completeness to step on W/O) *inspect fit of lid with base*****
157 - (Chemical Conversion Coat per QSI005 4.1) 1- realodine comers *do not acid etch*****
160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) 1- touch up corner with alodine only 2- Plug holes prior to finish 3-
Mask this area prior to finish View B-B 1ST COAT: START TIME: OVEN TEMPERATURE:
FINISH TIME: *** 2nd coat if necessary ***** 2ND COAT: START TIME:**
OVEN TEMPERATURE: FINISH TIME:
170 - (QC3- Inspect Part Finish)
180 - (Assemble as per dwg) 1- Install webbing as per dwg 2- Install placard and label as per dwg
190 - (QC5- Inspect part completeness to step on W/O)
200 - (Identify as per dwg & Stock Location:)
210 - (QC21- Final Inspection - Work Order Release)

#011650

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2957	Mounting Plate	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	S 083647
D3915-1	Rib	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	S 144789
D4016-5	Hinge Half, Light Lid	3 pcs (3 ea)	100-Large Fab - Welded Assy-1	S 039258
D4019-3	Rib	3 pcs (3 ea)	100-Large Fab - Welded Assy-1	S 084469
D4035-047	Lid Rib Assembly, Aft (Light)	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	S 213397
D4056-1	Label Plate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	S 067108
D4029-041	Webbing (Long Basket)	1 pcs (1 ea)	180-Handfinish - 4-1-Assembly-B4B	S 200089
MS20600-AD4W4	Rivet	34 Ea (34 ea)	180-Handfinish - 4-1-Assembly-B4B	S 141237
NAS1149DN949J	Washer	34 Ea (34 ea)	180-Handfinish - 4-1-Assembly-B4B	S 5071414/27x521791

-2

M. V. 012111

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2957	4	33	0
	D3915-1	2	8	0
	D4016-5	3	17	0
	D4019-3	3	8	0
	D4035-047	2	2	0
	D4056-1	1	11	0
180-Handfinish - 4-1-Assembly-B4B	D4029-041	1	5	0
	MS20600-AD4W4	34	2,055	0
	NAS1149DN949J	34	210	0
Part Specifications				
Specifications could not be found.				

Plex 5/13/19 10:50 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation				Disposition	
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____			
FAULT CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					